

Work Order ID 123832

123832

Page 1

Wednesday, August 27, 2014 1:56:46 PM

Item ID: 646.2900E Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Deflector **144**
Start Date: 8/29/2014 Start Qty: 120.00 ***120*** Cust Item ID:
Required Date: 8/29/2014 Req'd Qty: 120.00 ***120*** Customer:
Reference:

Approvals: Process Plan: CL Date: 14/08/27 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.2900									

100 0.00

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 25586

a) Description: EXTRUSION

e) Material: 7075-T6

f) Material certification required

0.00

CL 14/10/10 2 144

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

Ensure material certification is attached

0.00

0.00

180 SP 14-10-22

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

Ensure Material certification comply to Dwg 646.2900

0.00

0.00

CL 14/10/27

180

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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123832

Page 2

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Revision ID: Stop ***NS2***
Item Name: Deflector
Start Date: 8/29/2014 Start Qty: 120.00 ***120*** Cust Item ID:
Required Date: 8/29/2014 Req'd Qty: 120.00 ***120*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>MAT 35</i>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

14/10/27
14-10-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
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Picklist Print

Wednesday, August 27, 2014 1:56:46 PM

Page 1

Work Order ID: 123832

123832

Parent Item: 646.2900E

646 2900F

Parent Item Name: Deflector

Start Date: 8/29/2014

Required Date: 8/29/2014

Start Qty: 120.00

Required Qty: 120.00

Comments: IPP REV:A NEW ISSUE 12-10-30 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.2900P *646 2900P* Deflector		Manufactured	No				f	0.0000		120 114 180			

**

144x SP
14-10-22.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03694				SHEET 1 OF 1	
	DWG NO. 646.2900	REV: N/C	PREPARED BY B. PETERS	DATE: 11/14/12	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: DEFLECTOR					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE	REASON: ADDED ALTERNATE MATERIAL.				ECR: D-12-002	

IS

1 PRIMARY MATERIAL: 7075-T6 ALUMINUM PER AMS-QQ-A-225/9.
ALTERNATE MATERIAL: 7075-T6511 ALUMINUM PER AMS-QQ-A-200/11.

SHEET 1, ZONE A2 IS:

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				<input type="checkbox"/> RFMS <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input type="checkbox"/> ICA <input type="checkbox"/> BOM	CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE 03207			SHEET 1 OF 1	
	DWG NO. 646.2900	REV: N/C	PREPARED BY PB	DATE: 08/29/11	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNING.
	DWG TITLE: DEFLECTOR				
	APPROVED BY:	ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: ADDED ALTERNATE BASE MATERIAL			

SHEET 1, ZONE A2, NOTE 1 IS:

NOTES:

- 1 MATERIAL: 7075-T6 ALUMINUM PER AMS-QQ-A-225/9 OR AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2,
COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER;
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120

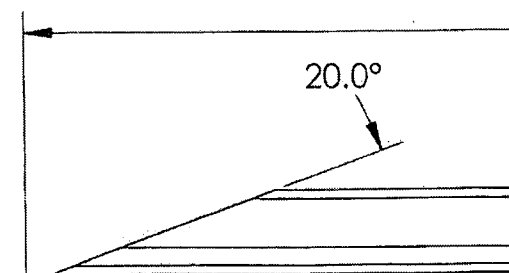
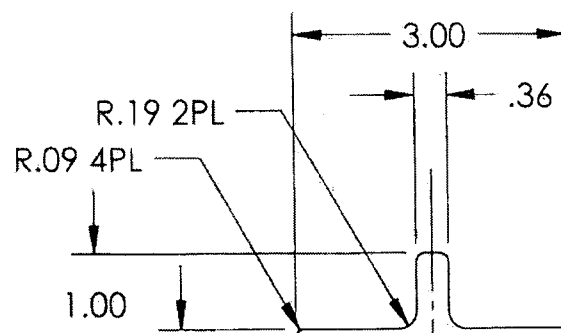
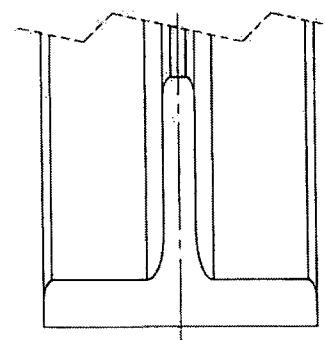
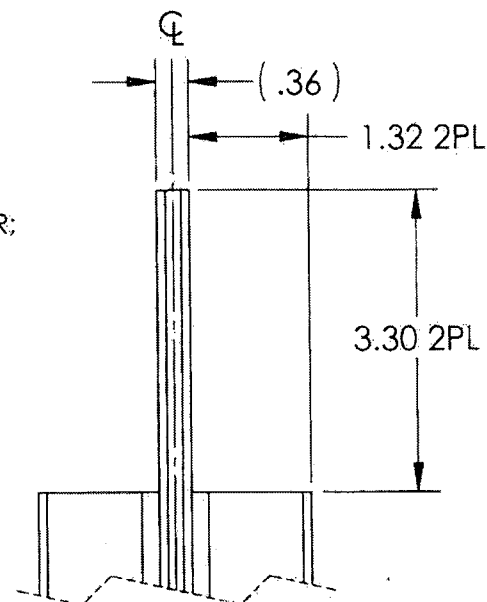
F/N	TC	PART NUMBER	QTY	DESCRIPTION				MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input type="checkbox"/> ICA <input type="checkbox"/> BOM				CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

1 2 3 4 5

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

NOTES:

- 1 MATERIAL: 7075-T6 ALUMINUM PER AMS-QQ-A-225/9
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2,
COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER;
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25586

Purchase Order Date 9/2/2014

PO Print Date 9/3/2014

Page Number 1 of 2

Order From :

VU-UAC001

Ship To : DART AEROSPACE LTD

UNIVERSAL ALLOY CORPORATION
2871 LA MESA
P.O. BOX 6316

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



ANAHEIM, CALIFORNIA 92816-8316
USA

REVISED

Contact Name

Buyer

Chantal Lavoie

Vendor Phone

678-880-1429

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

USD

Ship Via:

Journey Freight collect

FOB

FCA - (Free Carrier)

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pri
1	646.2900P	Deflector	10/10/2014 Yes 10/10/2014		144.00 Each	\$16.55	\$2,383.

AS PER DWG 646.2900 REV. N/C

B123832

SPECIFICATIONS: AMS-QQ-A-200/11

12 PCS OF 12 FT = 144 FT

QUOTATION NO. 353293

SP14-10-22

Line Total:

\$2,383.

Note:

9/3/2014

SHIPPER NO.

447902-1

UACPART NO.

66767

UNIVERSAL ALLOY CORPORATION
 2871 JOHN BALL WAY, P.O. BOX 6316, ANAHEIM, CA USA 92816-6316
 (714) 630-7200 (800) 331-7772 FAX (714) 630-7207

PRODUCTION LOTS

A625270

SHIP TO

DART AEROSPACE
1270 ABERDEEN

HAWKESBURY, ONTARIO CN, K6A 1K7

SHIP TO

DART AEROSPACE
1270 ABERDEEN

HAWKESBURY, ONTARIO CN, K6A 1K7

27/320

CUSTOMER'S P.O. NO.

PO25586 item 1

ORDER PLACED BY

CHANTAL LAVOIE

CUSTOMER'S PART NUMBER

646.2900-EXT ALUMINUM EXTRUSION

TERMS

NET 60

ALLOY

7075 T6511

SPECIFICATION NO.

AMS-QQ-A-200/11 REV. N/C

SHIP VIA

FORWARD AIR

DATE SHIPPED

10/11/2014

FREIGHT CHARGES

PREPAID ☒ COLLECT ☐

SHIPMENT

PARTIAL ☐ COMPLETE ☒

CERTIFICATIONS

ATTACHED ☒ TO FOLLOW ☐

QUANTITY SHIPPED

FEET

180

PIECES X LENGTH

15 X 144.

NET PER PC

12.93

NET POUNDS

194

GROSS POUNDS

223

BOX

1 bundle of 1 fiber board
with plywood caps
box

RECEIVED BY

X

DATE

TIME

UNIVERSAL ALLOY CORPORATION ACCEPTS NO RESPONSIBILITY FOR ERROR IN SHIPMENT IF YOU FAIL TO NOTIFY US WITHIN 3 DAYS OF RECEIPT. NO REJECTED MATERIAL WILL BE ACCEPTED FOR CREDIT OR REPLACEMENT AFTER 30 DAYS FROM DATE OF RECEIPT.

THIS SUPPLIER HAS BEEN DELEGATED BOEING INSPECTION AUTHORITY FOR ALL PARTS MANUFACTURED UNDER CONTRACT WITH THE BOEING COMPANY

SP14/10-22

SHIPPER NO.

447902-1

UACPART NO.

66767

UNIVERSAL ALLOY CORPORATION
 2871 JOHN BALL WAY, P.O. BOX 6316, ANAHEIM, CA USA 92816-6316
 (714) 630-7200 (800) 331-7772 FAX (714) 630-7207

PRODUCTION LOTS

A625270

SHIP TO

DART AEROSPACE
1270 ABERDEEN

HAWKESBURY, ONTARIO CN, K6A 1K7

SHIP TO

DART AEROSPACE
1270 ABERDEEN

HAWKESBURY, ONTARIO CN, K6A 1K7

27/320

CUSTOMER'S P.O. NO.

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ORDER PLACED BY

CHANTAL LAVOIE

CUSTOMER'S PART NUMBER

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SPECIFICATION NO.

AMS-QQ-A-200/11 REV. N/C

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FORWARD AIR

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10/11/2014

FREIGHT CHARGES

PREPAID ☒ COLLECT ☐

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PARTIAL ☐ COMPLETE ☒

CERTIFICATIONS

ATTACHED ☒ TO FOLLOW ☐

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NET PER PC

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NET POUNDS

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GROSS POUNDS

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1 bundle of 1 fiber board
with plywood caps
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THIS SUPPLIER HAS BEEN DELEGATED BOEING INSPECTION AUTHORITY FOR ALL PARTS MANUFACTURED UNDER CONTRACT WITH THE BOEING COMPANY

UNIVERSAL ALLOY CORPORATION

2871 JOHN BALL WAY ANAHEIM, CA 92806 (714) 630-7200

EXTRUSION MILL CERTIFICATE OF CONFORMANCE INSPECTION AND TEST REPORT

CUSTOMER DART AEROSPACE LTD

PURCHASE ORDER PO25586 item 1

DATE 10/11/14

ORDER NUMBER 447902

PART NO. 646.2900-EXT rev N/C

SPECIFICATIONS AMS-QQ-A-200/11 REV. N/C

MATERIAL 7075-T6511

MECHANICAL PROPERTIES

SAMPLE OR LOT	TEST DIRECTION	TEST LOCATION	TENSILE STRENGTH KSI	YIELD STRENGTH KSI	ELONGATION %
<u>A625270</u>	L		88.6	80.7	13.5

REF CUST. P/N: 646.2900 REV. N/C B123832

mk 14/10/27

MANUFACTURED IN THE U.S.A.

CHEMICAL COMPOSITION LIMITS										
ALLOY NOS	SI	FE	CU	MN	MG	CR	ZN	TI	EACH	OTHERS TOTAL
<u>7075</u>	0.40	0.50	1.2-2.0	0.30	2.1-2.9	0.18-0.28	5.1-6.1	0.20	0.05	0.15

THIS IS TO CERTIFY THAT THE MATERIAL APPLIED TO THE ABOVE ORDER COVERED BY THIS REPORT HAS BEEN INSPECTED IN ACCORDANCE WITH THE SPECIFICATIONS DESCRIBED FORMING A PART OF THIS ORDER AND THAT REPRESENTATIVE MATERIAL HAS BEEN TESTED AND FOUND TO MEET THE APPLICABLE REQUIREMENTS. FURTHER SHOWN ARE THE COMPOSITION LIMITS AND MECHANICAL PROPERTY TEST RESULTS. DOCUMENTATION VERIFYING CONFORMANCE TO THESE REQUIREMENTS IS ON-FILE AND SUBJECT TO EXAMINATION.

PERCENT MAXIMUM UNLESS SHOWN OTHERWISE
REMAINDER ALUMINUM

UNIVERSAL ALLOY CORPORATION

Mark Briguglio
Mark Briguglio Metallurgical Lab Manager
QUALITY ASSURANCE DEPARTMENT



A25270T04

UAC UNIVERSAL ALLOY CORPORATION[®]

A COMPANY OF MONTANA TECH COMPONENTS AG

2871 John Ball Way
Anaheim, California 92806-0316
714.630.7200 - 800.331.7772 - Fax 714.630.7207

Invoice Number: 714156

Please Remit To:

Universal Alloy Corporation
P.O. Box 732418
Dallas, TX 75373-2418

Please Send All Correspondence to: 180 Lamar Haley Pkwy. Canton, GA 30114

Sold To:
DART AEROSPACE
1270 ABERDEEN

Shipped To:
DART AEROSPACE
1270 ABERDEEN

HAWKESBURY, ONTARIO, CN K6A 1K7

HAWKESBURY, ONTARIO, CN K6A 1K7

27/320

Date 10/11/2014	Shipped Via JOURNEY FREIGHT	Shipper No. 447902-1	Date Shipped 10/11/2014	Terms NET 60
Purchase Order Number FO25586		Part Number 646.2900-EXT Rev N/C		Die Number 7B1443
QUANTITY	DESCRIPTION	UNIT PRICE	AMOUNT	
180.000	ALUMINUM EXTRUSION	16.550/FT	\$2,979.00	
NO REJECTED MATERIAL WILL BE ACCEPTED FOR CREDIT OR REPLACEMENT AFTER 30 DAYS FROM DATE OF RECEIPT. UNIVERSAL ALLOY CORP. ACCEPTS VISA, MASTERCARD, AND AMERICAN EXPRESS.				\$2,979.00

TOTAL
U.S. Dollars

CUSTOMER COPY

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 646.2900E
 RECEIVED BY: Sonia P
 DATE: 14/10/22
 P/O#: 25586
 QUANTITY ORDERED: 144
 THICKNESS ORDERED: 3.00X1.00X.36
 SHEET SIZE: _____
 MATERIAL CERT RECEIVED: yes
 QUANTITY RECEIVED: 180
 THICKNESS RECEIVED: 3.06X1.00X.36
 SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y <input checked="" type="checkbox"/>	
INCORRECT FINISH	Y <input checked="" type="checkbox"/>	
CORROSION	Y <input checked="" type="checkbox"/>	
INCORRECT GRAIN DIRECTION	Y <input checked="" type="checkbox"/>	
INCORRECT MATERIAL	Y <input checked="" type="checkbox"/>	
INCORRECT THICKNESS	Y <input checked="" type="checkbox"/>	
PHOTO REQUIRED	Y <input checked="" type="checkbox"/>	
CORRECT MATERIAL	<input checked="" type="checkbox"/> N	
CORRECT REF # TO LINK CERT	<input checked="" type="checkbox"/> N	
CORRECT MATERIAL IDENTIFICATION	<input checked="" type="checkbox"/> N	
CORRECT M# ON THE MATERIAL	<input checked="" type="checkbox"/> N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y <input checked="" type="checkbox"/>	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y <input checked="" type="checkbox"/>	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D	
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>CSK</u>	BY: _____		
DATE: <u>14/10/22</u>	DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASES ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER